

Work Order ID 57827

April 16, 2010 11:31:43 AM



Page 1

Item ID: D2230-3

Accept



Setup Start



Revision ID:

Item Name: Lug

Stop



Start Date: 16/04/2010 Start Qty: 100.00



Cust Item ID:

Required Date: 16/04/2010 Req'd Qty: 100.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 10-4-14

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2230

Rev F

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut D2423 extrusion to 0.82"
Batch: 45800

10.4.27

100

0

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine per folio D2230-3
Check for crack while loading into the machine.
2- deburr

10.4.27
10/04/29

100

0

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

10.4.27

100

0

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

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Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

aml 10/04/29

100

Ø

150

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

100

BK 10-5-3

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

JD 10/05/03

100

Ø

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Page 3

Item ID: D2230-3

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Item Name: Lug

Stop



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Cust Item ID:

Required Date: 16/04/2010 Req'd Qty: 100.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

M114207

0.00

Memo

START TIME: 8:00pm

OVEN TEMPERATURE: 320°C

FINISH TIME: 8:30am

0.00

7M 10/05/04

100

9

180



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

7M-1 10/05/04

100X

190



Packaging

Packaging

Identify as per dwg & Stock Location: SK

Memo

0.00

0.00

EP 10/05/05 100

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

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Page 4

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Start Date: 16/04/2010 Start Qty: 100.00



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Required Date: 16/04/2010 Req'd Qty: 100.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/06

C2101515

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

Picklist Print

April 16, 2010 11:31:47 AM

Page 1

Work Order ID: 57827



Parent Item: D2230-3



Parent Item Name: Lug

Start Date: 16/04/2010

Required Date: 16/04/2010

Comments: IPP ☐ D ☐ 00.05.18 ☐ Added inspection level 8, and removed P/O for powder coat ☐ EC ☐

Start Qty: 100.00

Required Qty: 100.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| D2423 | | Manufactured | No | | | 100 | f | 524.7499 | 7.1895 | | | |
| | | | | | | | | | | | | |
| Lug Extrusion | | | | | | | | | | | | |

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT06

524.7499

43722

180

45800

344.7499

_____ *10.05.05*

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NOTE: Date & initial all entries

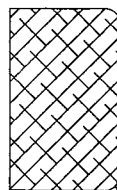
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE

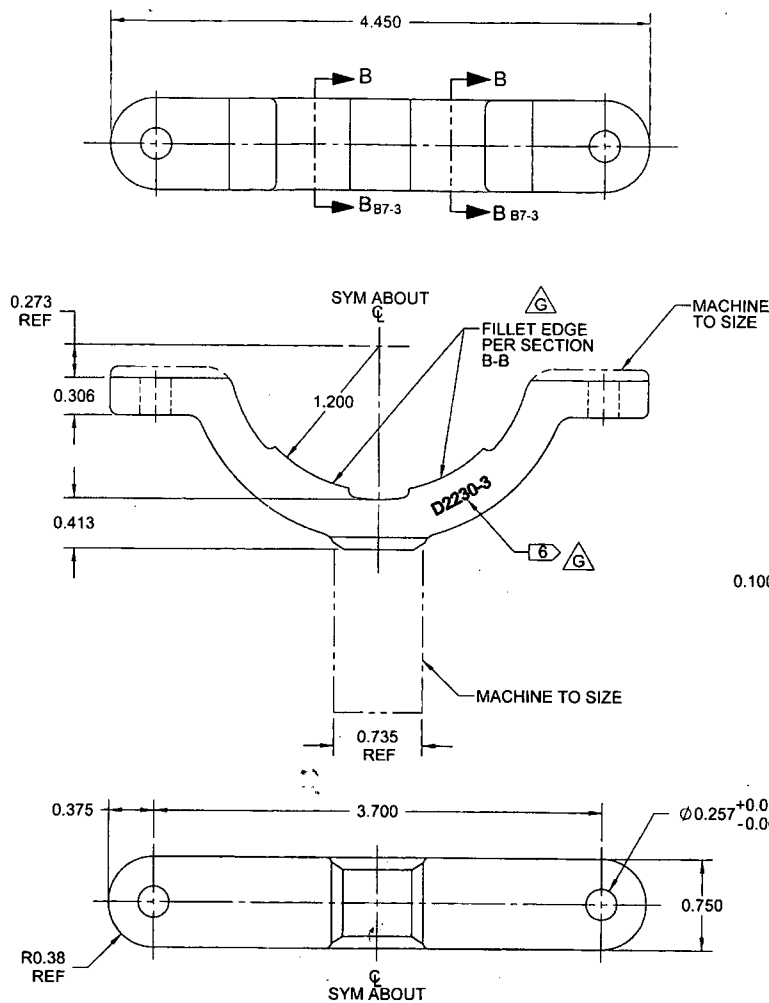
WORK ORDER

NO. 37827

BS10-4-14



$\triangle G$ SECTION B-B D4-3
SCALE 2X
R0.06 MIN - R0.10 MAX
2 PL



D2230-3 MOUNTING LUG

RELEASED
09/06/23

| | | | |
|------------|----------|--|--------------|
| DESIGN | BW | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | AJS | | |
| CHECKED | | DRAWING NO. D2230 | REV. G |
| MFG. APPR. | | TITLE | SHEET 3 OF 3 |
| APPROVED | | MOUNTING LUG | SCALE |
| DE APPR. | | | NTS |
| DATE | 09.01.16 | COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |

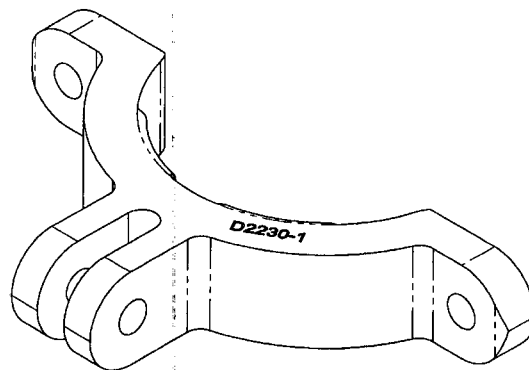
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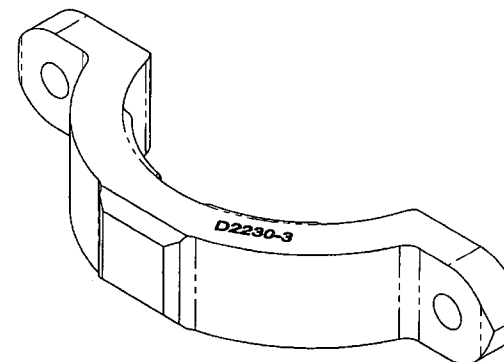
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NOTE: Date & initial all entries



D2230-1 MOUNTING LUG



D2230-3 MOUNTING LUG

W/O 57827

RELEASED
09/06/15



NOTES:

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS OF 0.015 ± 0.005.
- 7) WEIGHT: -1: 0.16 lbs
-3: 0.14 lbs

| | | | | |
|------------|---|--|-----|--------------|
| G | REDESIGNED IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. REFER TO SECTION A-A & B-B FILLET ADDED TO PREVENT CHAFING OF RUBBER CUSHION ON INSTALLATION. | | AJS | 09.01.16 |
| F | REDESIGN: R1.200 WAS 1.100 | | CP | 99.12.13 |
| E | RE-DESIGN | | BW | 95.01.04 |
| D | RE-DESIGN | | BW | 95.01.04 |
| C | RE-DESIGN | | BW | 94.03.30 |
| REV. | DESCRIPTION | | BY | DATE |
| DESIGN | BW | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | | |
| DRAWN | AJS | | | |
| CHECKED | | DRAWING NO. | | REV. G |
| MFG. APPR. | | D2230 | | SHEET 1 OF 3 |
| APPROVED | | TITLE | | SCALE |
| DE APPR. | | MOUNTING LUG | | NTS |
| DATE | 09.01.16 | <small>COPYRIGHT © 1994 BY DART AEROSPACE LTD. INC.</small> <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | | |

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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

C

B

A

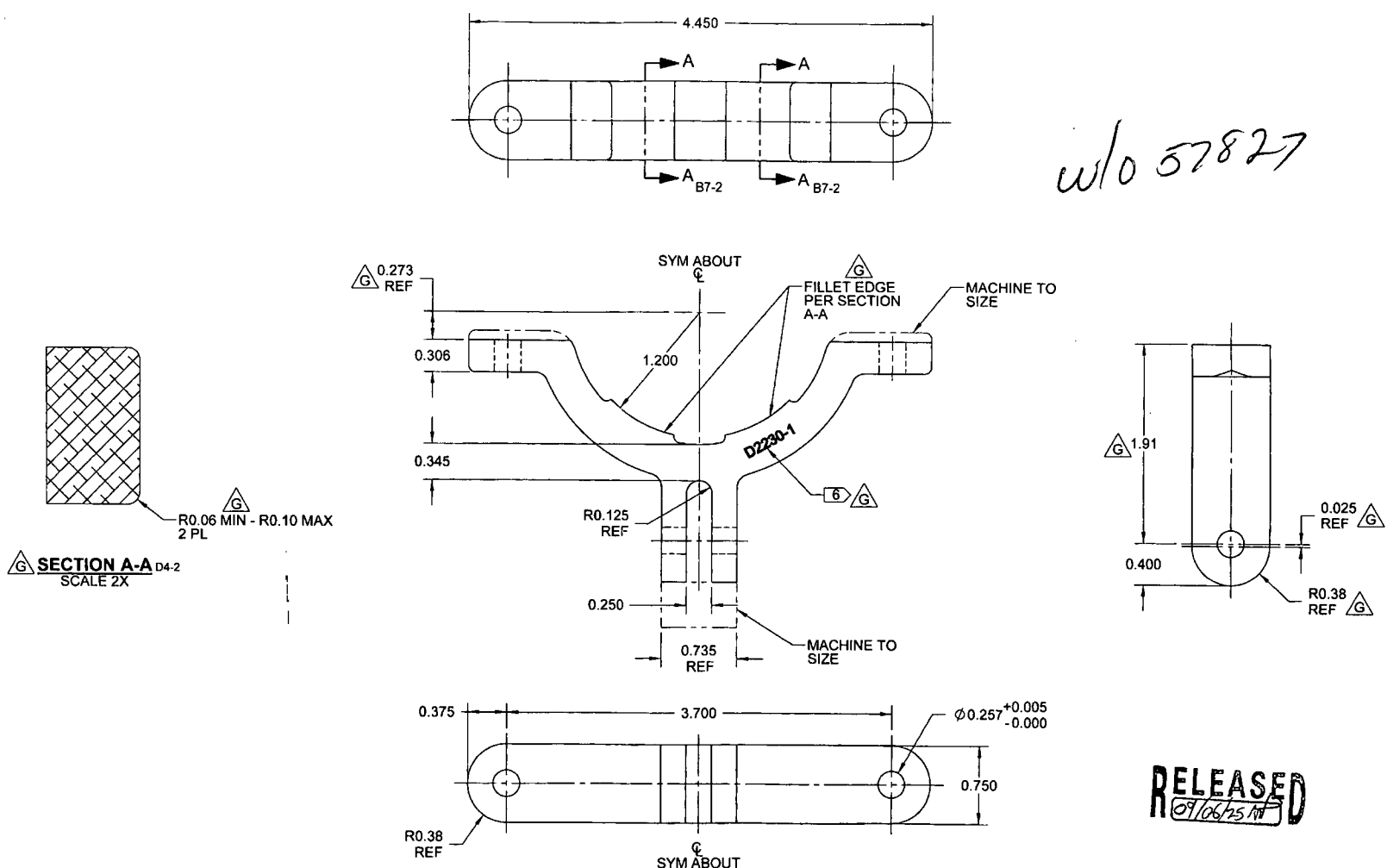
D

C

B

A

w/o 57827



SECTION A-A D4-2
SCALE 2X

D2230-1 MOUNTING LUG

RELEASED
09/06/25/17

| | | | |
|------------|----------|--|--------------|
| DESIGN | BW | DART AEROSPACE LTD | |
| DRAWN | AJS | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. D2230 | REV. G |
| MFG. APPR. | | TITLE MOUNTING LUG | SHEET 2 OF 3 |
| APPROVED | | SCALE | NTS |
| DE APPR. | | COPYRIGHT © 1994 BY DART AEROSPACE LTD | |
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8 7 6 5 4 3 2 1

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